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TITLE : PRODUCTION OF NONWOVEN FABRIC COMPOSITE SHEET

ABSTRACT : PURPOSE: To provide a method for production of a nonwoven fabric composite sheet having a uniform weave, excellent in surface properties, capable of efficiently removing fine dirt and reduced in coming-off of pulp during use.

CONSTITUTION: A thermoplastic resin such as polypropylene or polyethylene terephthalate is discharged through a thin hole to form a fine fiber of ≤ 1.5 denier using a high-temperature and high-speed gas and the resultant fine fibers are collected in the form of sheet to prepare a melt blow sheet of 3 to 80g/m² weight. A paper sheet prepared by paper-making of wood pulp and having 10 to 100g/m² weight is put on the surface of the above-mentioned sheet in layers to obtain a laminate. As necessary, another melt blow sheet is further put on the paper sheet in layers. The weight ratio of the total weight of the melt blow sheet to that of the paper sheet is (melt blow sheet)/(paper sheet) = 1/0.25 to 33. A high-pressure water stream treatment is applied from the paper sheet surface to the melt blow sheet side in the case of a two-layer laminate or from one side or both the sides of the laminate in the case of a three-layer laminate, thus producing the objective nonwoven fabric composite sheet in which the fine fibers of the melt blow sheet are entangled and integrally combined with the pulp fibers of the paper sheet.

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